












Date: Tuesday, 1/24/2006 2:45:24 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 25601	Part Number	: D33407
Estimate Number	: 11352	Drawing Number	: D3340 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 1/24/2006 S.O. No. : N/A	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Due Date	: 1/31/2006
Previous Run	: 25190	Qty:	2 Um: Each
Written By	: _____		
Checked & Approved By	: _____		
Comment	: Est: A 05/11.10 Preliminary issue AP/EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
			
Comment: PURCHASING Issue P/O: 2008674 Email of ship DXF file to vendor Laser Cut per Dwg D3340 flat pattern D3340-7 Material release note required			
2.0	D33407F	Wearplate	
			
Comment: Qty.: 1.0000 U(s)/Unit Total : 2.0000 U(s) Wearshoe			
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material release note is attached			
4.0	QC6	DIMENSIONAL CHECK	
			
Comment: DIMENSIONAL CHECK Inspect dimensions			
5.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE Deburr if necessary Form on brake as per Dwg D3340 using Jigs DT and DT			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 27/01/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/24/2006 2:45:25 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 25601

Part Number: D33407

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*260027 (2)*

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*FC 06 09 07 (2)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*PC 6/14/22 (2)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57363*

*PC 6/12/22 (2)*

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21'

*DP 07/01/08*

Job Completion



*UL 06/12/29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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(09) 235 8888 / 235 3535 Waiuku  
Fax: (09) 375 8858

# TEST CERTIFICATE

Ref: 5005/21329

CUSTOMER	Willdson	P41007DI002	SPECIFICATION	ASTMA1088 CS Type A	CERTIFICATE No	TC107796																		
CUSTOMER O/N	90-21N-288		PRODUCT	CRA WIDE COIL	PAGE	1 of 1																		
MILL O/N	453665		DIMENSIONS	0.033" x 48" x Coil	DATE	31 March 2005																		
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTM A378)								
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ( )	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100				x1000										x10000		x100	180°				GL=	HRB
R9-455932-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				41		2621
R9-455933-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				41		2723
R9-455934-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				50		2546
R9-455935-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				50		2789

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	(C)=5mm x 5mm	CARBON EQUIVALENT VALUE (CE)	(C)=C+Mn/8+Si/24
(A)=0.2% PROOF STRESS	(A)=200mm (C)=80mm (E)=2"	(A)=r0 (C)=r45	(A)=10mm x 10mm	(D)=2.5mm x 10mm	(A)=C+Mn/8	(D)=
(B)=LOWER YIELD STRESS	(B)=50mm (D)=5.65 x So (F)=8"	(B)=r90 (D)=(r0+r90+2r45) / 4	(B)=7.5mm x 10mm	(E)=5mm x 10mm	(B)=C+Mn/8+(Cr+V+Mo)/5+(Cu+Ni)/15	

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

*Satish Misra*  
QC METALLURGIST

20 GA CRMS

550711MD014-1 T M INDUSTRIAL (P41007DI002.640077)

Drawing name..... D3340-7A1  
Revision.....  
Material number..... 0003, MILD STEEL 20GA, .036  
Last modified date... 10-20-2005  
Programmed by..... jm

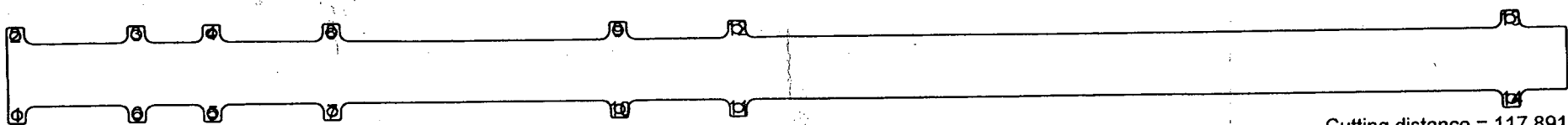
Comment.....  
Customer name... Dart  
Description.....  
Specification.....

m19186

DWL CHECK: 05/12/02

(2)

REFERENCE ONLY





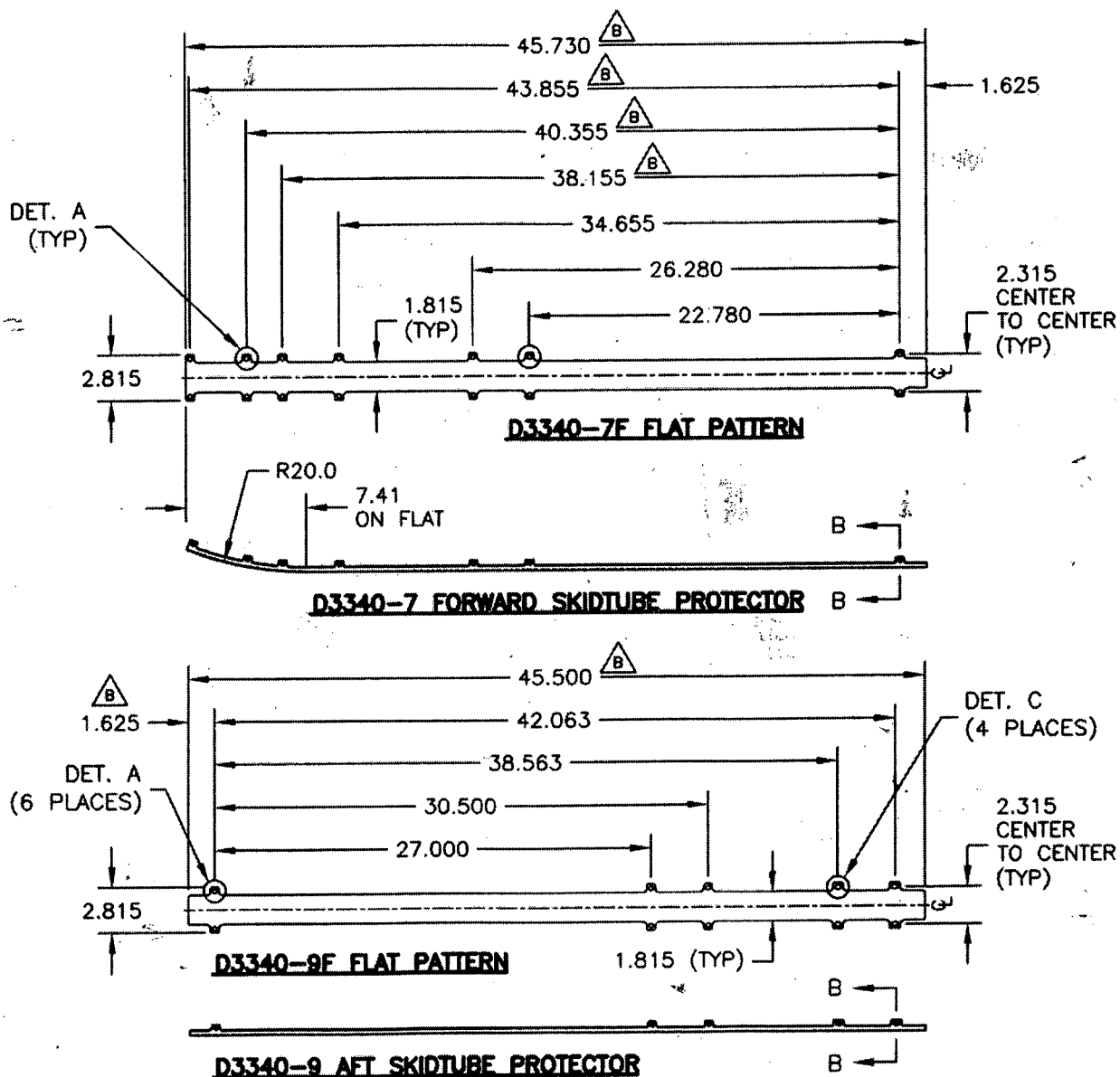
Cutting distance = 117.891  
Rapid distance = 64.1548

2.815 x 45.73

1=5

**DART**

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3340	REV. B SHEET 4 OF 11
DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

**RELEASED**  
05.11.28

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